

Work Order ID 59262

Friday, May 28, 2010 9:27:17 AM



Page 1

Item ID: D2330-15

Accept



Setup Start



Revision ID:

Item Name: Frame

Stop



Start Date: 5/28/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 10528

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2330

G

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D2330
2- remove identification marks and deburr

SAJ 11-06-20

Handwritten circled number 2

110

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Handwritten signature/initials

120

0.00



Packaging

Memo

0.00

Packaging

Identify as per dwg & Stock Location: *WA*

SAJ

11-06-20

W/O: 59262		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-06-20	110	permanent change	EE	11.06.21	N/A	U mubd	Co 11/06/21

Part No: D2330-15 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Frame

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Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/21

MF-11-06-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, May 28, 2010 9:27:21 AM

Page 1
1

Work Order ID: 59262



Parent Item: D2330-15



Parent Item Name: Frame

Start Date: 5/28/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 09.03.18 New Issue EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	1,116.480	2.9	5.8			



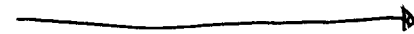
304 SQ Tube .75x.75x.065W



SAD 11-06-20

Location	Loc Qty	Loc Code
MAT	116.48021	
112398	0	
114482	116.48021	
WA	1000	
114520	1000	

m117598



5.8

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 59262
B-10-5-28

RELEASED
9/12/12 MP

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. REV. G D2330 SHEET 1 OF 6 TITLE SCALE BASKET ASSEMBLY (206B) NTS	
DATE	09.02.05	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE KEPT UNDER LOCK AND KEY AND NOT TO BE LOANED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

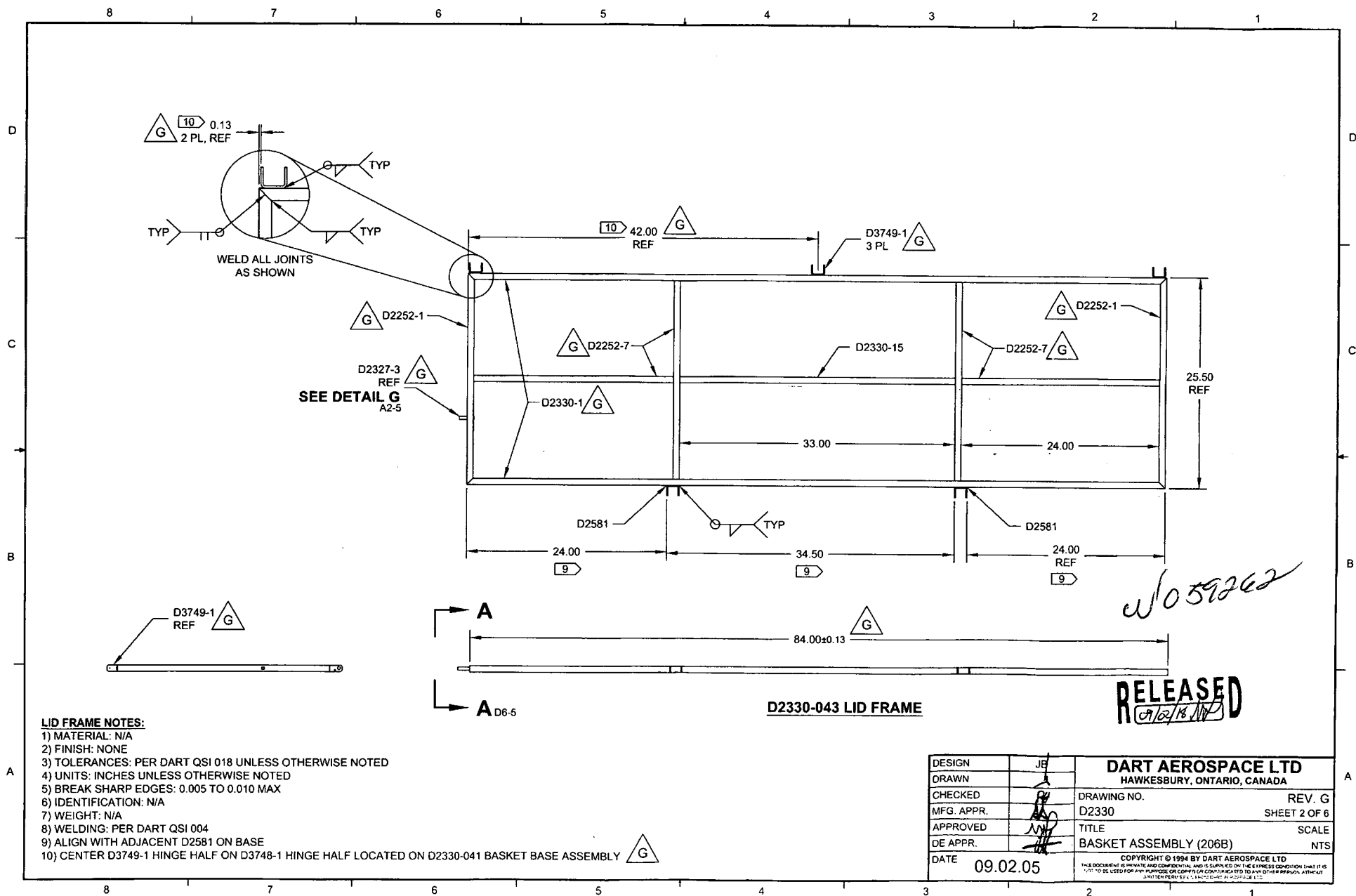
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



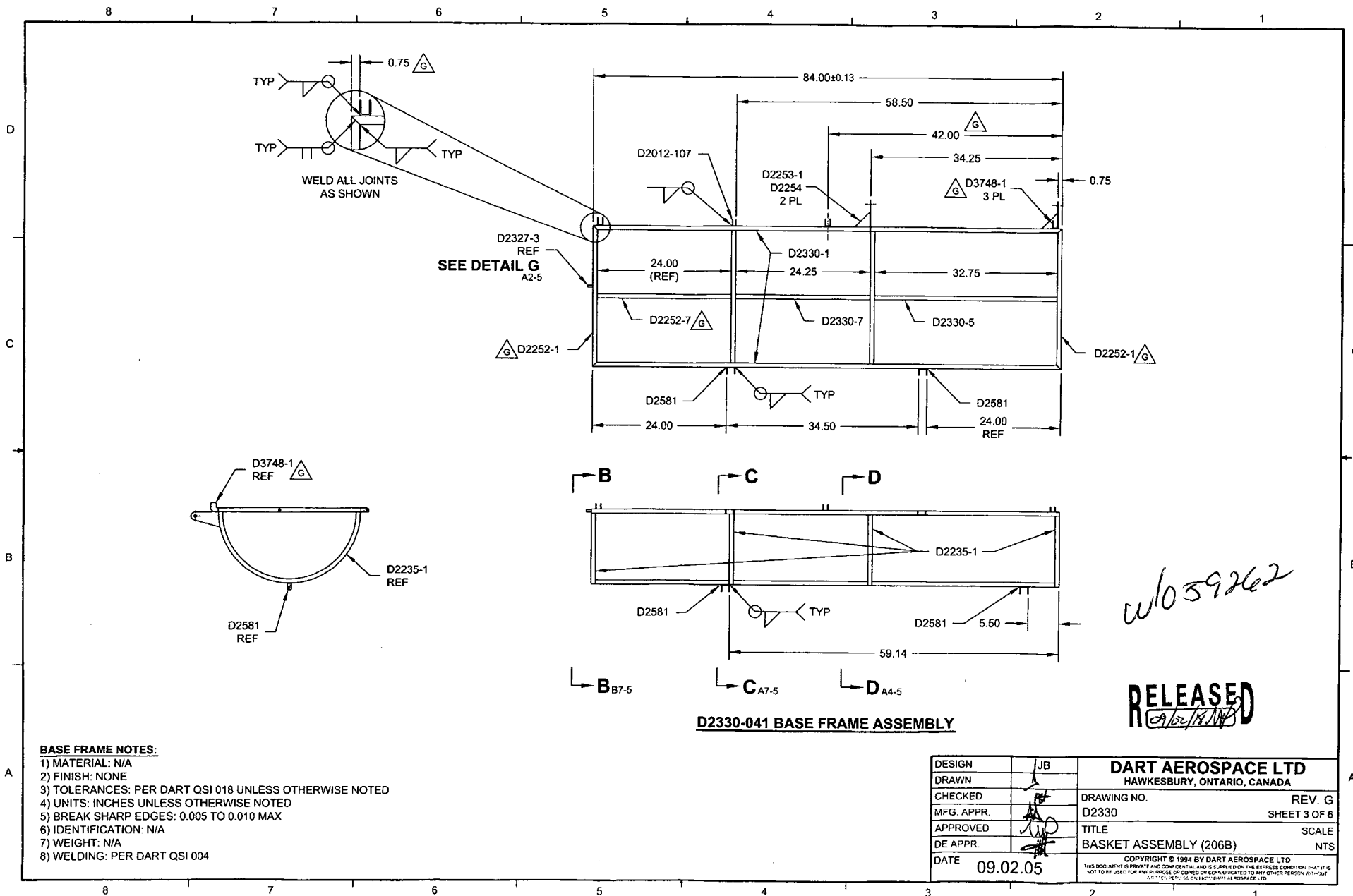
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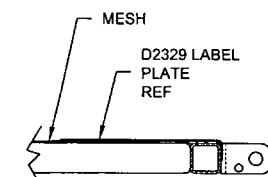
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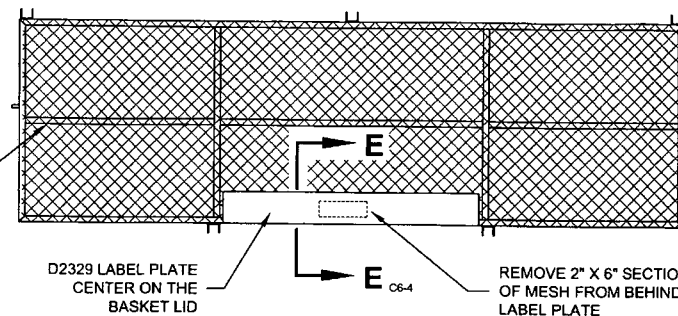
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

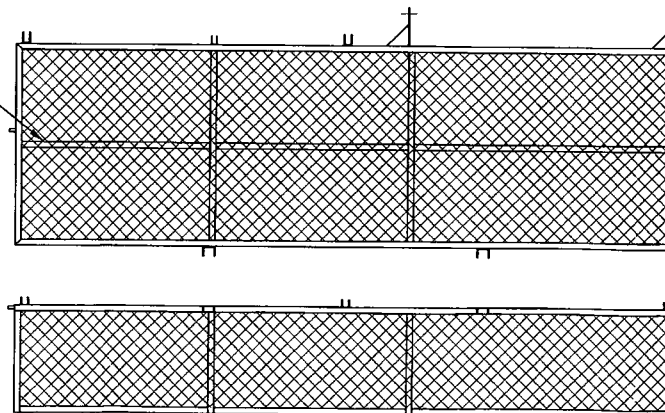


SECTION E-E C3-4
VIEW ROTATED 90° CCW

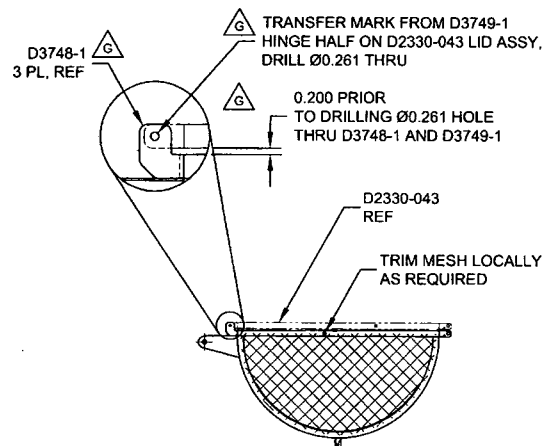
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2330	REV. G
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE BASKET ASSEMBLY (206B)	SCALE
DE APPR.			NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

RELEASED
09/02/05

w/o 59262

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

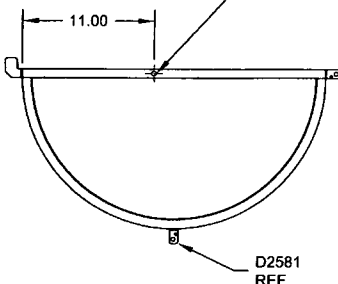
B

A

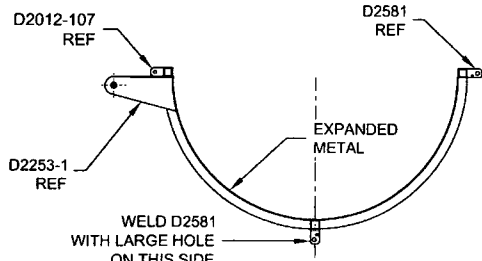


VIEW A-A A6-2

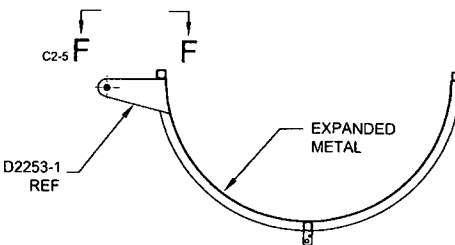
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



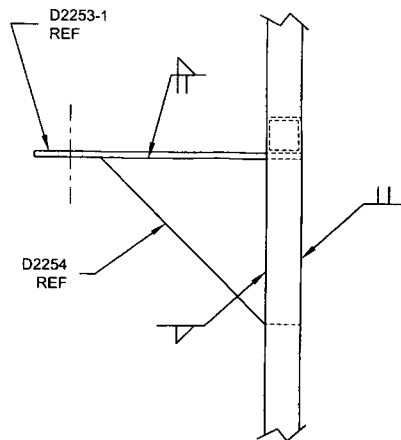
VIEW B-B A5-3



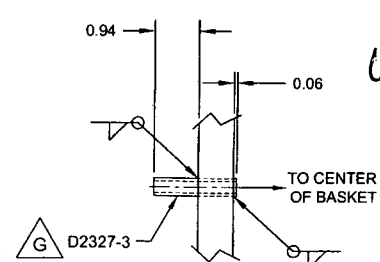
SECTION C-C A4-3



SECTION D-D A3-3



VIEW F-F B6-5
SCALE 4X



DETAIL G
SPACER INSTALLATION
SCALE 4X

w/0 39262

RELEASED
13/12/84

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2330	REV. G
MFG. APPR.			SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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8 7 6 5 4 3 2 1

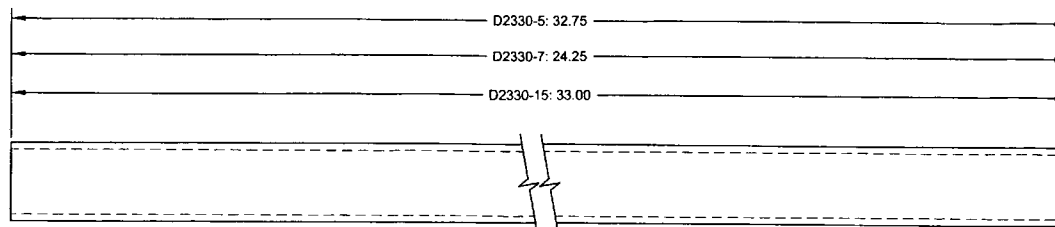
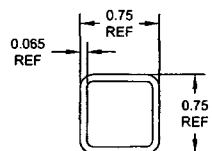
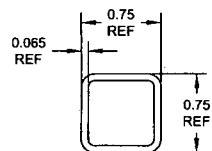
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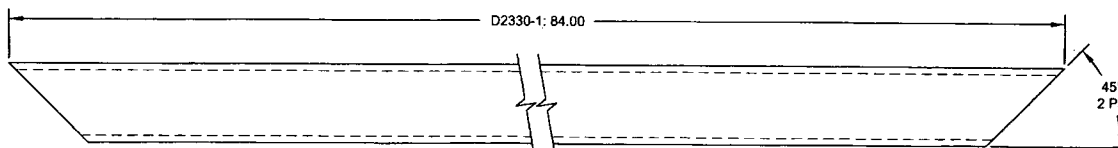
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D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

W1059262

RELEASED
9/2/18

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2330	SHEET 6 OF 6
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